

ASAP

Work Order ID 50591

July 16, 2009 10:42:35 AM



Item ID: D3578-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Doubler

Start Date: 7/17/09 Start Qty: 40.00



Cust Item ID:

Required Date: 7/20/09 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3578

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3578 (Run prog. D3578-1)

Dwg Rev: A

Prog

Rev: A 2-Deburr if necessary

=> ml 09 07 16 (40)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

=> ml 09 07 16 (40)

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

=> 8 09/16/12 (40) f

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

1-Open rivet holes to 0.098" and C'sink as per dwg D3578

Small Fab

EP 09/07/20 (40)
Debra M.H. 09/07/16 (40x)

140

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

=> S 09/07/20 (x40) f

150

0.00



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

UMD 09/07/20 (x40)

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Required Date: 7/20/09 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

40

170



Small Fab

Small Fab

Small Fab

Memo

1-Assemble as per dwg D3578

0.00

0.00

EP 09/07/20 40

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

=> 50/10/20 40

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Cust Item ID:

Required Date: 7/20/09 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

9/7/2009 40x Sep

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/21

MF 09-07-21

Picklist Print

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Page 1

Work Order ID: 50591

Parent Item: D3578-041RevA

Parent Item Name: Doubler

Comments:

Start Date: 7/17/09

Required Date: 7/20/09

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3569-IRevA

Manufactured

No

110

Each

22.0000

40.0000



Decal

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

22

32084

22

M6061T6S.080

Purchased

No

170

sf

190.9800

0.2947



6061-T6 .080 Sheet

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

190.98

107272

1.25

110254

2.5

110630

43.23

112040

80

112141

64

MA 09 07 16

Picklist Print

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Work Order ID: 50591

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Parent Item Name: Doubler



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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD3-3		Purchased	No			110	Each	8,232.000	80.0000			
												
Rivet												

EP 09/07/20

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

8232

1563

0

19099

4776

7681

3456

80

MS21075L3

Purchased

No

170

Each

162.0000

40.0000



Nutplate



EP 09/07/20

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

162

109068

12

109371

39

110704

37

111477

74

40

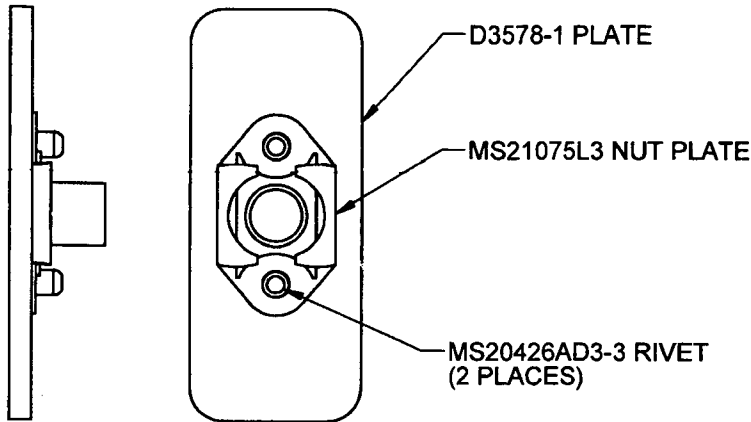
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Shop Packet Print

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DART

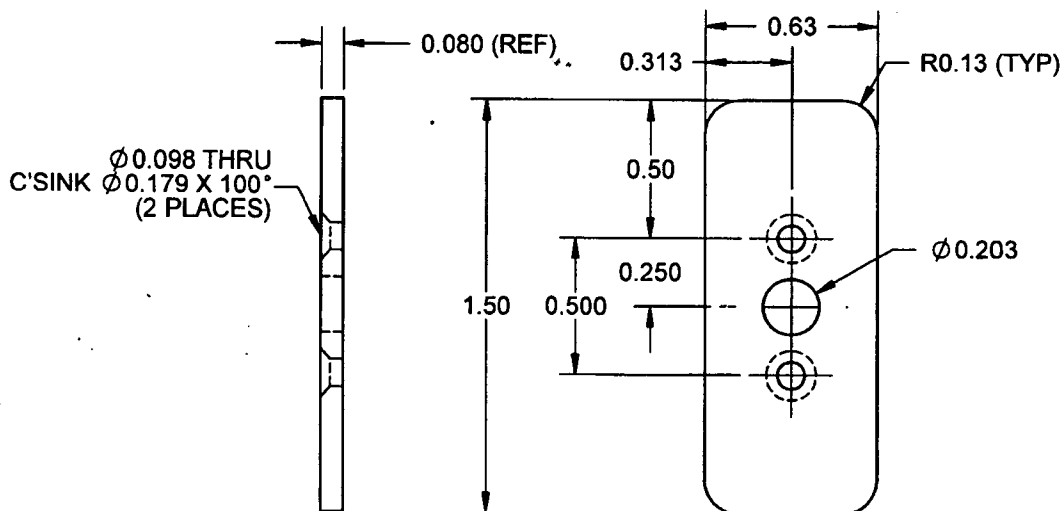
DESIGN <i>LET</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3578	REV. A SHEET 1 OF 1
DATE 07.01.12	TITLE DOUBLER		SCALE 3:2
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE	

**RELEASED**
07-04-02 #1**D3578-041 PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

D3578-041 DOUBLER**D3578-041 NOTES:**

- 1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER

**D3578-1 PLATE****D3578-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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